

Date: Wednesday, 1/11/2006 4:25:10 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG EXTRUSION		
Job Number	: 25452					
Estimate Number	: 10326					
P.O. Number	: N/A			Part Number	: D27317	
This Issue	: 1/11/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2731 REV B	
First Issue	: N/A		Type	: MACHINED PARTS		
Previous Run	: 23331			Project Number	: N/A	
Written By	: SEE COMMENT Below			Drawing Revision	: B	
Checked & Approved By	: SEE ABOVE. USER & DATE			Material	: N/A	
Comment	: Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC			Due Date	: 1/30/2006	
					Qty:	50 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
	Comment: Qty.: 0.0717 f(s)/Unit Total : 3.5858 f(s)	
	Lug Extrusion D2423	
	Batch: B23779	M8 06/01/23
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW	
	Cut D2423 extrusion to .82"	Batch B23779 M8 06/01/23
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	
	1-Machine as per folio D2731-7.	Metec P.O. # 00000416 AL
	2-Check for crack while loading into the machine.	06/01/23
	3-Tumble	
	4-Deburr any rough edges after tumbling	
3.6	RG Receive + Inspect for frost damage	CY06/01/23 50
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC3	SECOND CHECK
	Comment: SECOND CHECK	JAN-03-02 50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:25:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 25452

Part Number: D27317

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/03/05

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M 06/03/14 (50)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06/03/14 (50)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 148

M 06/03/17 (50)

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(50)

06/03/21

Job Completion



U 06/03/21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

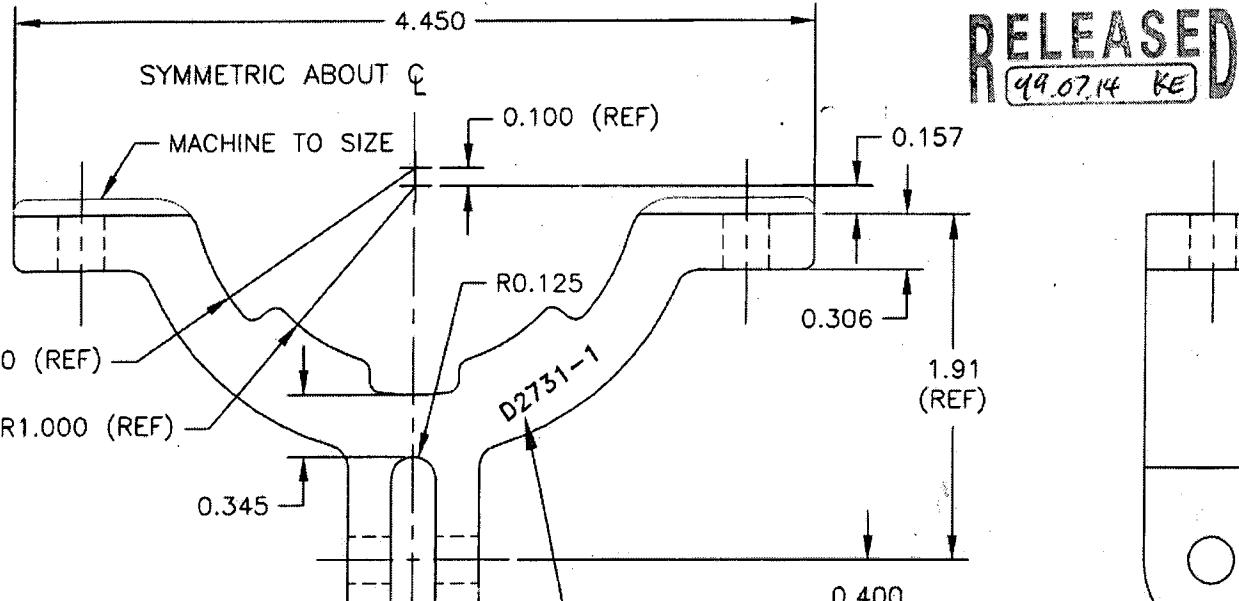
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

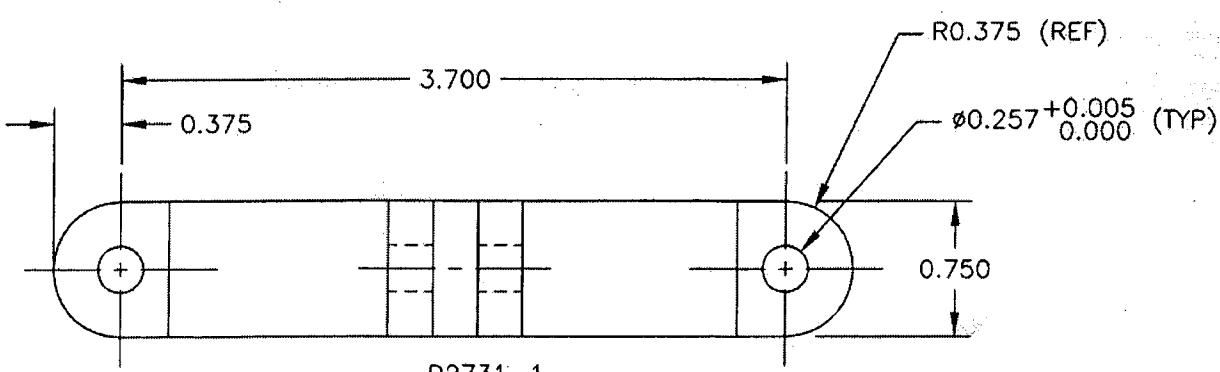
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JX</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 1 OF 4
		TITLE MOUNTING LUG
A.	98.05.13	SCALE 1:1
B	99.07.06	REVISED DIMENSIONS



ENgrave PART NUMBER
TO DEPTH OF 0.010 ± 0.005
IN THIS LOCATION, WITH TOOL
TIP RADIUS OF 0.015 ± 0.005



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PULL CUP
ST TO AMENDMENT
WITHOUT NOTICE

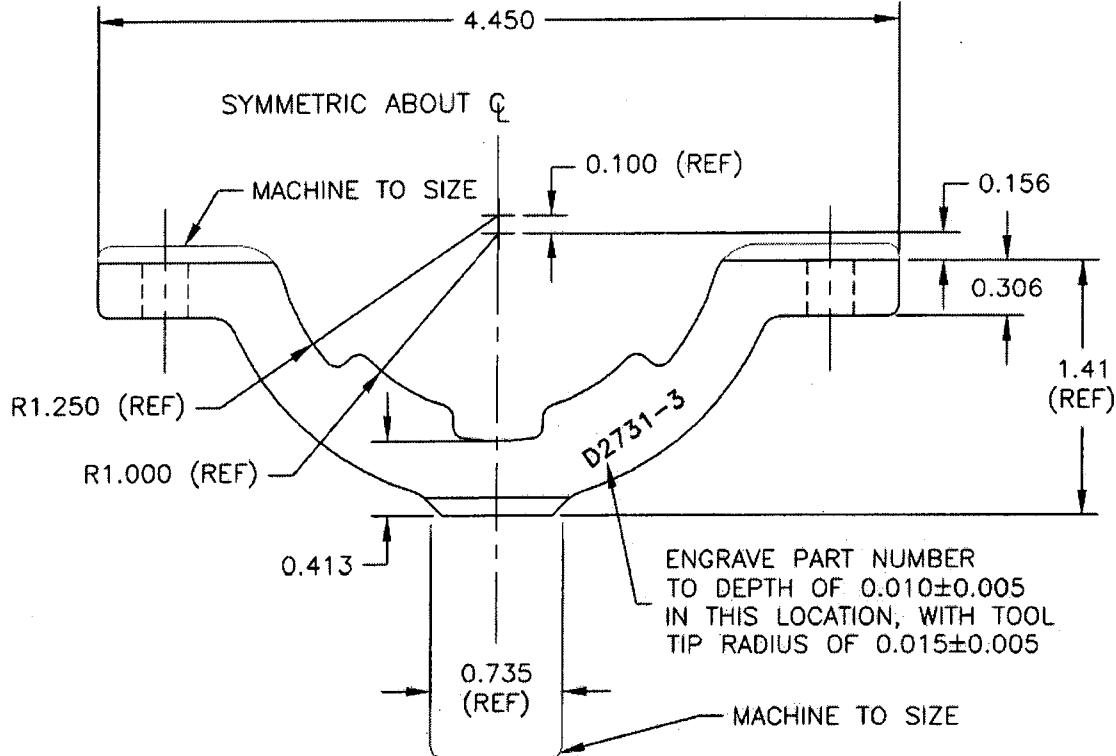
DART

DESIGN KE	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED KE	APPROVED <i>[Signature]</i>	DRAWING NO. D2731
DATE 99.07.06		TITLE MOUNTING LUG

REV. B
SHEET 2 OF 4

1:1

RELEASED
19.07.14 KE



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

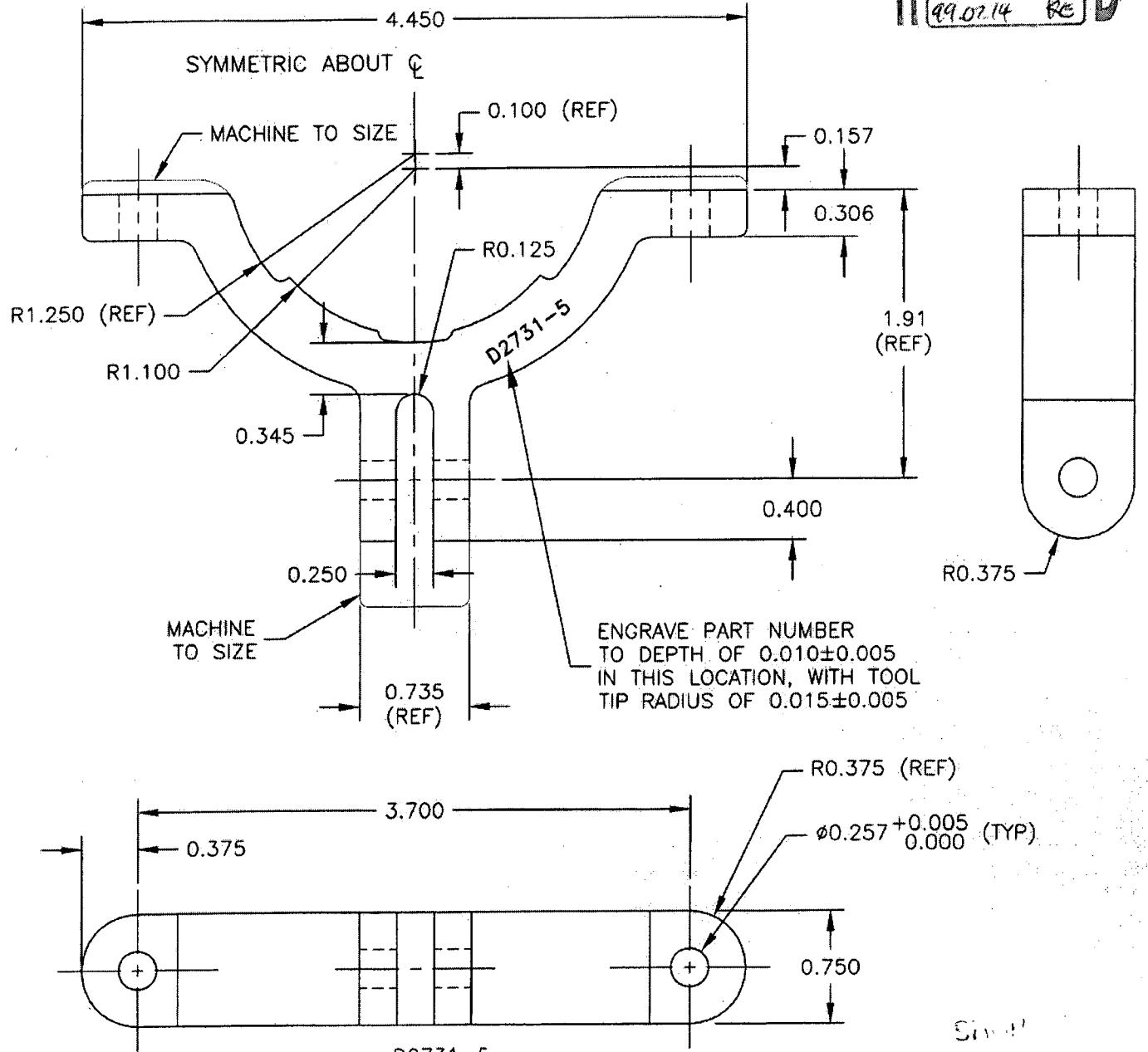
WORK ORDER
NO 25452

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D2731
DATE 99.07.06		TITLE MOUNTING LUG

REV. B
SHEET 3 OF 4

1:1

RELEASED
99.07.14 *KE*

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 SUBJECT TO APPROVAL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT EXCEPTION

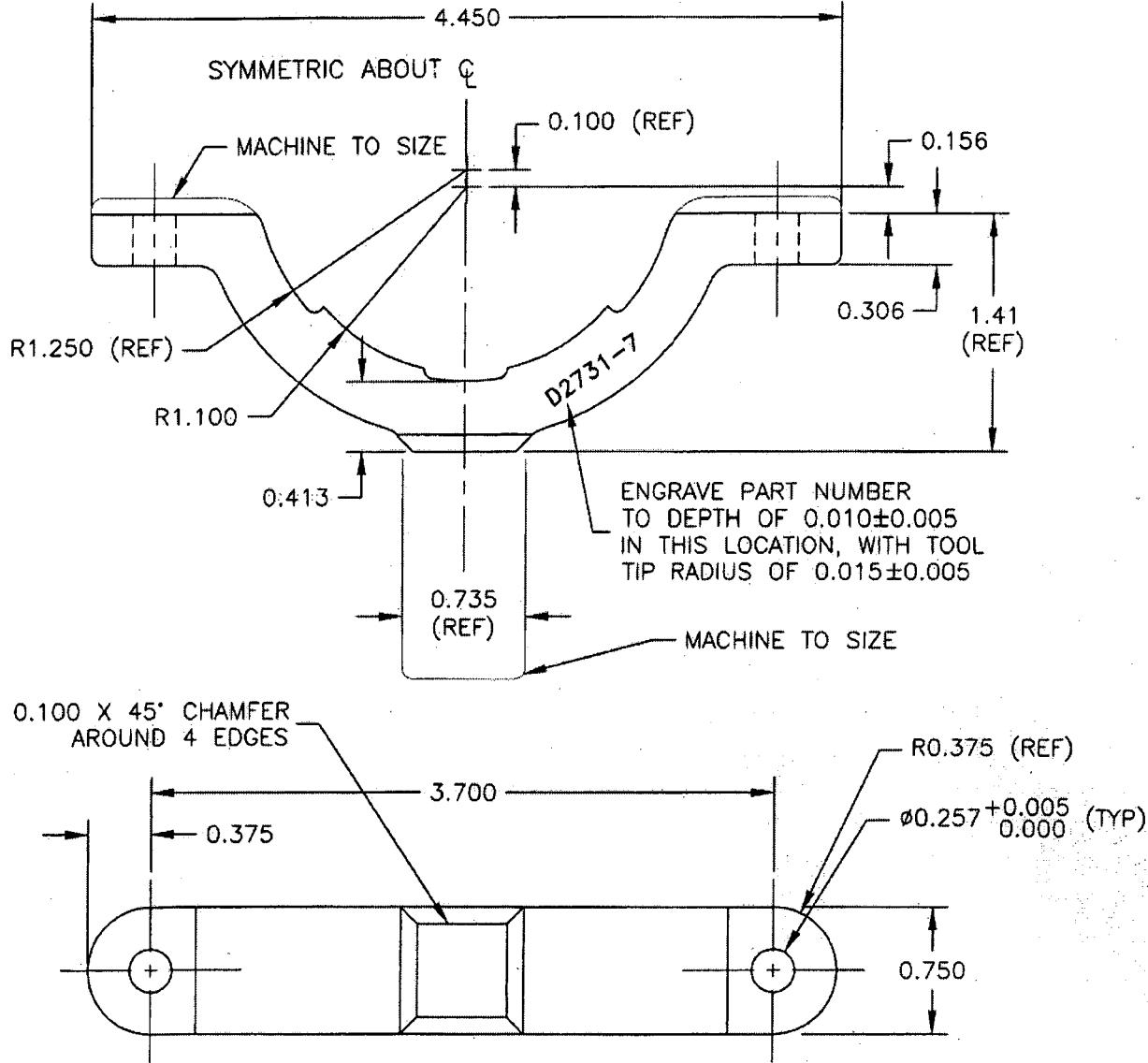
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ENGINEERING

WORK ORDER

NO. 25452

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>SJ</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*D2731-7

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGINEERING

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WITHOUT NOTICE



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D2731-7	Mounting Lug	446

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in cursive ink, appearing to read "Shigi Regula Walz".

Shigi (Regula) Walz

Vankleek Hill, February 28, 2006

A handwritten signature in cursive ink, appearing to read "John Walz".